

Work Order ID 66032

Wednesday, February 02, 2011 10:21:48 AM

Page 1

Item ID: D3210-1

Revision ID:

Item Name: Doubler

Start Date: 2/2/2011 Start Qty: 12.00

Required Date: 2/3/2011 Req'd Qty: 12.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3210

Rev A

100

0.00



Waterjet

FLOW CNC Waterjet

Memo

0.00

1-Cut as per Dwg D3210  
Deburr if necessary

Dwg Rev: A

Prog Rev: A

12-

B 11-2-2

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

B 11-2-2

120

QC8- Inspect parts - second check

0.00



QC

Quality Control

Memo

0.00

8/2/2011

42

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Page 2

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Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



Small Fab

Small Fab

Small Fab

Memo  
Debur

0.00

0.00

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

12. BR 11-02-3.

# Work Order ID 66032

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Required Date: 2/3/2011

Req'd Qty: 12.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

Powdercoat

*m 112588*

Powder Coating

Memo

0.00

START TIME:

*1:40*

OVEN TEMPERATURE:

FINISH TIME:

*2:10*

*12. BR 11-02-3.*

170

QC3- Inspect Part Finish

0.00

QC

Quality Control

Memo

0.00

*=> MU 11/02/03*

*12*

180

Identify as per dwg & Stock Location

0.00

Packaging

Memo

0.00

*210*

*11/2/350 (12A)*

**Work Order ID 66032**

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Item ID: D3210-1

Accept

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Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/02/04  
MF  
11-02-03

# Picklist Print

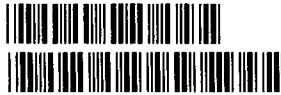
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Page 1

Work Order ID: 66032

Parent Item: D3210-1

Parent Item Name: Doubler



Start Date: 2/2/2011

Required Date: 2/3/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 05-11-17 JLM  
IPP Rev:B Now On Waterjet 06-10-24 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.080		Purchased	No			100	sf	145.7000	1.7	21.47368			



2024-T3 .080 sheet



811-2-2

Location

Loc Qty

Loc Code

MAT

96

116604

96

116604

MAT22

49.7

104921

2

105411

7

109424

3

110347

3

110908

2

112331

3

113796

9.7

114025

20

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	<i>1405</i>
<b>Description:</b> Doubler		<b>Part Number:</b>	<b>D3210-1</b>
<b>Inspection Dwg:</b> D3210	<b>Rev:</b> A		<b>Page 1 of 1</b>

## FIRST ARTICLE INSPECTION CHECKLIST

[illegible]

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 11-2-2	Date: 11/02/03	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.12.15	New Issue P/O D350-567-015/-025/-031	KJ/RF	
B	04.06.15	Removed 14.607 dimension	KJ/JLM	

**DART**



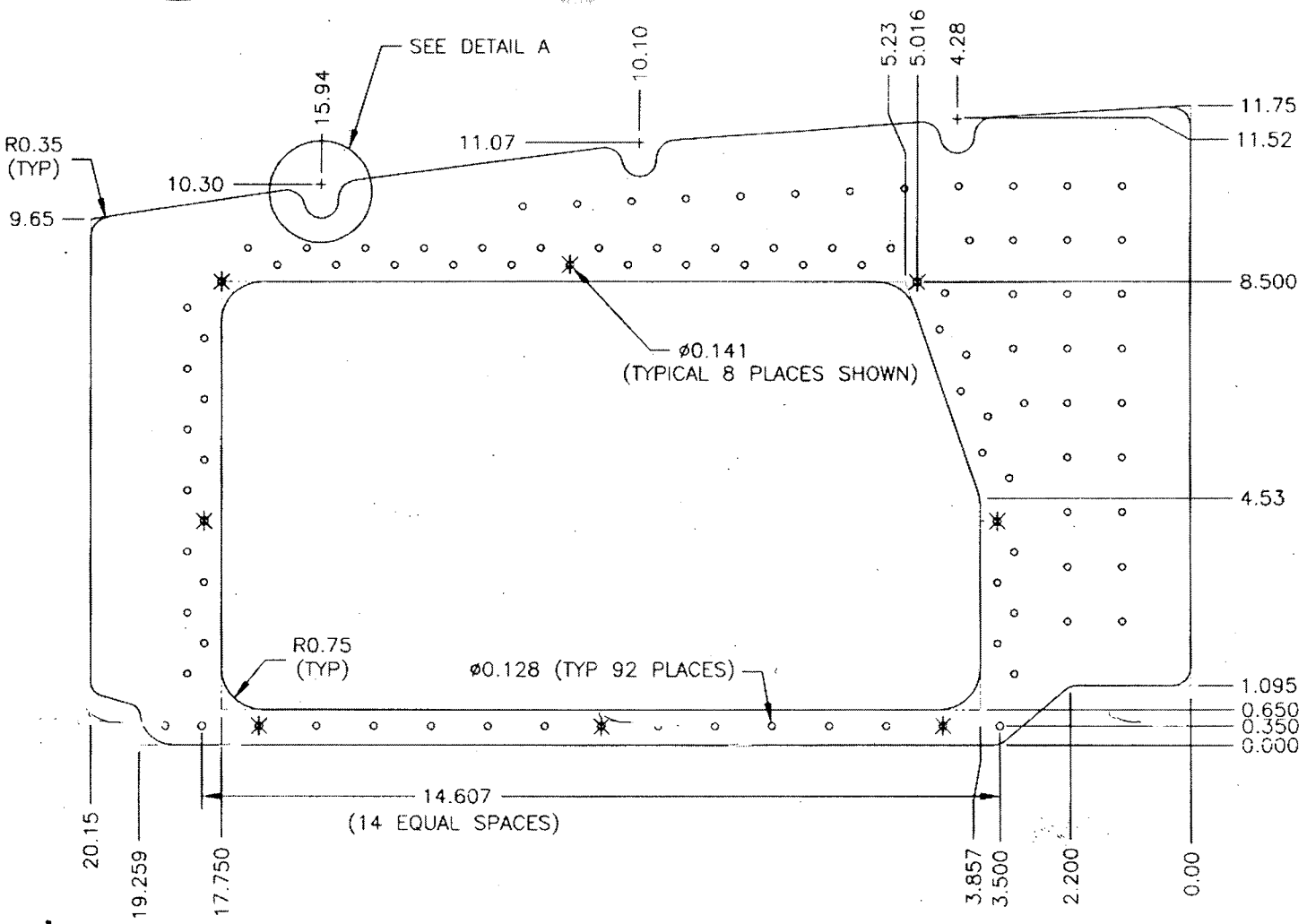
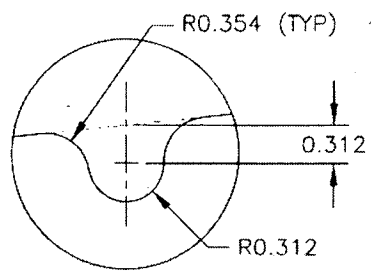
*Handwritten:* 2309032

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
DATE		D3210	SHEET 1 OF 1
03.09.03		TITLE	SCALE
		DOUBLER	1:3
A	03.09.03	NEW ISSUE	

**D3210-1 DOUBLER**

MAKE PER DRAWING FILE "D3210-A1.DWG"  
 CHECK PER TEMPLATE D3210-1T1  
 DIMENSIONS SHOWN FOR REFERENCE ONLY  
 MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.080 THICK  
 FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
 POWDER COAT BLACK SANDTEX (REF. 4.3.5.7) PER  
 DART QSI 005 4.3  
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**DETAIL A**  
 SCALE 2:3



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